

# Work Order ID 65636

January 20, 2011 1:28:55 PM



Page 1

Item ID: D119-675-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 1/20/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| N/A                            | Rev N/A                  |                      |         |        |              |               |               |                  |                |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675011 CHG003

CHG004 5/10/15

11/3/2 BG 11-3-2

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/2 (20) SP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/10/15

x2  
1HC

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January 20, 2011 1:28:55 PM



Page 2

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Start Date: 1/20/11 Start Qty: 2.00



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Required Date: 2/04/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-675-011

Location: 82

Rec'd

1/24/3/16

(2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/16

UME

11-03-16

# Picklist Print

January 20, 2011 1:28:53 PM

Page 1

Work Order ID: 65636

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01  
IPP RevE change at rev.b as per ECN1107 DD verified by:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|           |  |              |    |  |  |     |      |        |  |  |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|--|--|--|--|--|
| D3043-041 |  | Manufactured | No |  |  | 110 | Each | 0.0000 |  |  |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|--------|--|--|--|--|--|



Step Weldment LH, A119

|           |  |              |    |  |  |     |      |         |  |  |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|---------|--|--|--|--|--|
| D2182B032 |  | Manufactured | No |  |  | 120 | Each | 20.0000 |  |  |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|---------|--|--|--|--|--|



Rubber Cushion

cut at 4 per kit  
@ 3-2011  
measured  
8/16/11

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

|       |    |  |
|-------|----|--|
| ST402 | 20 |  |
|-------|----|--|

|       |    |  |
|-------|----|--|
| 63469 | 20 |  |
|-------|----|--|

|       |  |              |    |  |  |     |      |          |  |  |  |  |  |
|-------|--|--------------|----|--|--|-----|------|----------|--|--|--|--|--|
| D2274 |  | Manufactured | No |  |  | 120 | Each | 270.0000 |  |  |  |  |  |
|-------|--|--------------|----|--|--|-----|------|----------|--|--|--|--|--|



Radius Block

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

|       |     |  |
|-------|-----|--|
| ST010 | 270 |  |
|-------|-----|--|

|       |   |  |
|-------|---|--|
| 61361 | 1 |  |
|-------|---|--|

|       |   |  |
|-------|---|--|
| 63990 | 6 |  |
|-------|---|--|

|       |    |  |
|-------|----|--|
| 64771 | 63 |  |
|-------|----|--|

|       |     |  |
|-------|-----|--|
| 65047 | 200 |  |
|-------|-----|--|

|         |  |              |    |  |  |     |      |         |  |  |  |  |  |
|---------|--|--------------|----|--|--|-----|------|---------|--|--|--|--|--|
| D2617-3 |  | Manufactured | No |  |  | 120 | Each | 49.0000 |  |  |  |  |  |
|---------|--|--------------|----|--|--|-----|------|---------|--|--|--|--|--|



Bushing

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

|       |    |  |
|-------|----|--|
| ST020 | 49 |  |
|-------|----|--|

|       |    |  |
|-------|----|--|
| 52651 | 49 |  |
|-------|----|--|

B65637 11/13/11  
1.066 feet 6x extra  
B39986 11/13/11

B65562 11/13/11

11/13/11

# Picklist Print

January 20, 2011 1:28:53 PM

Page 2

Work Order ID: 65636

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

D2617-5

Manufactured No

120

Each

39.0000



Spacer

8 16 11/3/2 SP B66157 (6x)

## Location

## Loc Qty

## Loc Code

ST020

39

52648

39

D2732

Manufactured No

120

f

553.8793

1.066



Rubber Extrusion

10 2132 11/3/2 SP

## Location

## Loc Qty

## Loc Code

ST410

500

64283

500

ST412

53.879279

56516

53.879279

D3041-1

Manufactured No

120

Each

4.0000



Clamp

4 8 11/3/2 SP B65638 SP 11/3/16

## Location

## Loc Qty

## Loc Code

ST463

4

51159

4

D3041-3

Manufactured No

120

Each

6.0000



Clamp

4 4 11/3/2 SP (20)

## Location

## Loc Qty

## Loc Code

ST463

6

51114

6

January 20, 2011 1:28:53 PM

Shop Packet Print

Page 2

# Picklist Print

January 20, 2011 1:28:53 PM

Page 3

Work Order ID: 65636

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00



Clamp

Manufactured No 120 Each 23.0000



8

11/3/25

## Location

## Loc Qty

## Loc Code

ST457

23

48241

23

Purchased No 120 Each 300.0000



8

11/3/25



Bolt

## Location

## Loc Qty

## Loc Code

ST357

300

110382

100

115316

200

Purchased No 120 Each 271.0000



8

11/3/25



Bolt

## Location

## Loc Qty

## Loc Code

ST357

271

112314

71

115371

40

115422

160

Purchased No 120 Each 51.0000



8

11/16/2016 11/3/25



Bolt

## Location

## Loc Qty

## Loc Code

ST358

51

114784

9

115108

5

115936

37

January 20, 2011 1:28:53 PM

Shop Packet Print

Page 3

# Picklist Print

January 20, 2011 1:28:54 PM

Work Order ID: 65636

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

AN960JD416

NAS1149D0463J Purchased

No

120

Each

30.0000

12 24



Washer



11/68 05 11/3/25

## Location

## Loc Qty

## Loc Code

ST300

24

113288

24

ST356

6

115622

6

MS21042L4

Purchased

No

120

Each

4,398.000

12 24



Nut



11/3/2 sl (20)

## Location

## Loc Qty

## Loc Code

ST300

4398

1123143

2

115589

10

115621

21

116188

3500

116548

865

24

REFERENCE ONLY.

## 4.0 WEIGHT AND BALANCE:

| Installation                 | Weight  | LATERAL   |             | LONGITUDINAL |            |
|------------------------------|---------|-----------|-------------|--------------|------------|
|                              |         | Arm       | Moment      | Arm          | Moment     |
| D119-675-011                 | 11.5 lb | - 32.4 in | - 373 in-lb | 121.3 in     | 1395 in-lb |
| <b>HELI-ACCESS-STEP™, LH</b> | 5.2 kg  | - 1.28 m  | - 6.7 m-kp  | 3.08 m       | 16.0 m-kp  |
| D119-675-012                 | 11.5 lb | +32.4 in  | +373 in-lb  | 121.3 in     | 1395 in-lb |
| <b>HELI-ACCESS-STEP™, RH</b> | 5.2 kg  | +1.28 m   | +6.7 m-kp   | 3.08 m       | 16.0 m-kp  |

## 5.0 PARTS LIST:

| Qty<br>-011 | Qty<br>-012 | Part Number  | Description           |
|-------------|-------------|--------------|-----------------------|
| X           |             | D119-675-011 | HELI-ACCESS-STEP™, LH |
|             | X           | D119-675-012 | HELI-ACCESS-STEP™, RH |
| 4           | 4           | D2182B032    | RUBBER CUSHION        |
| 8           | 8           | D2274        | RADIUS BLOCK          |
| 4           | 4           | D2617-3      | BUSHING               |
| 8           | 8           | D2617-5      | BUSHING               |
| 4           | 4           | D2732-032    | RUBBER CUSHION        |
| 4           | 4           | D3041-1      | CLAMP                 |
| 2           | 2           | D3041-3      | CLAMP                 |
| 4           | 4           | D3042-1      | CLAMP                 |
| 1           |             | D3043-041    | STEP WELDMENT LH      |
|             | 1           | D3043-042    | STEP WELDMENT RH      |
| 4           | 4           | AN4-15A      | BOLT                  |
| 4           | 4           | AN4-11A      | BOLT                  |
| 8           | 8           | AN4-12A      | BOLT                  |
| 12          | 12          | AN960JD416   | WASHER                |
| 12          | 12          | MS21042L4    | NUT (OR MS21042-4)    |

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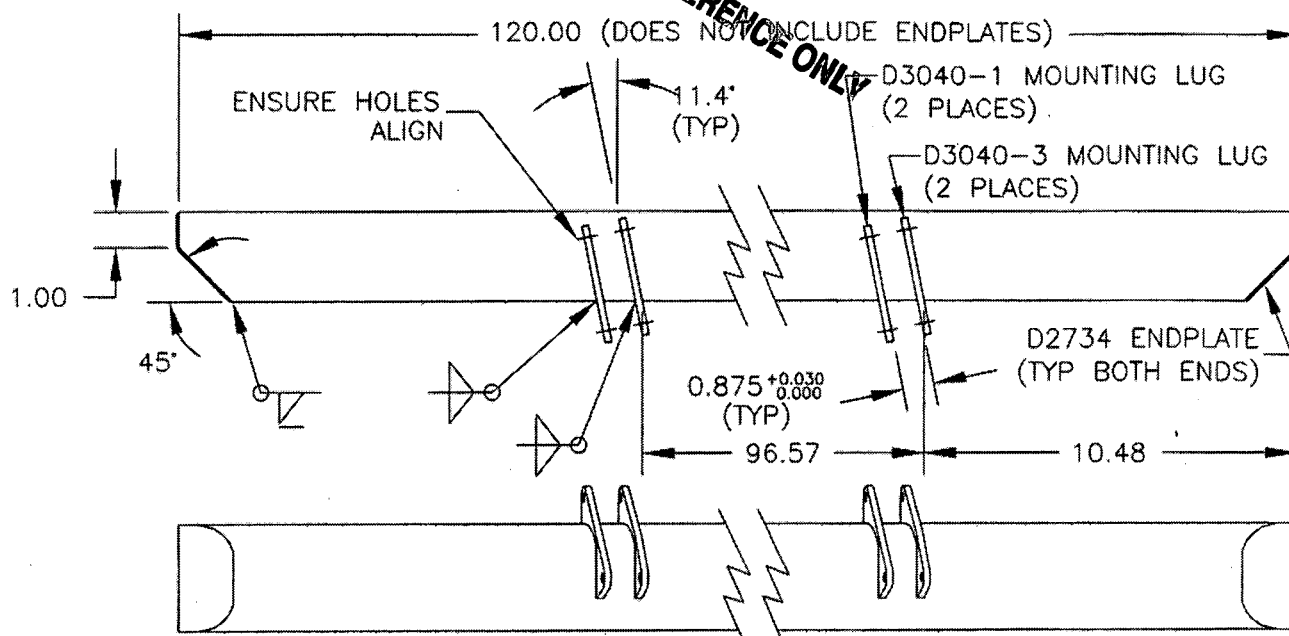
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Revision: B

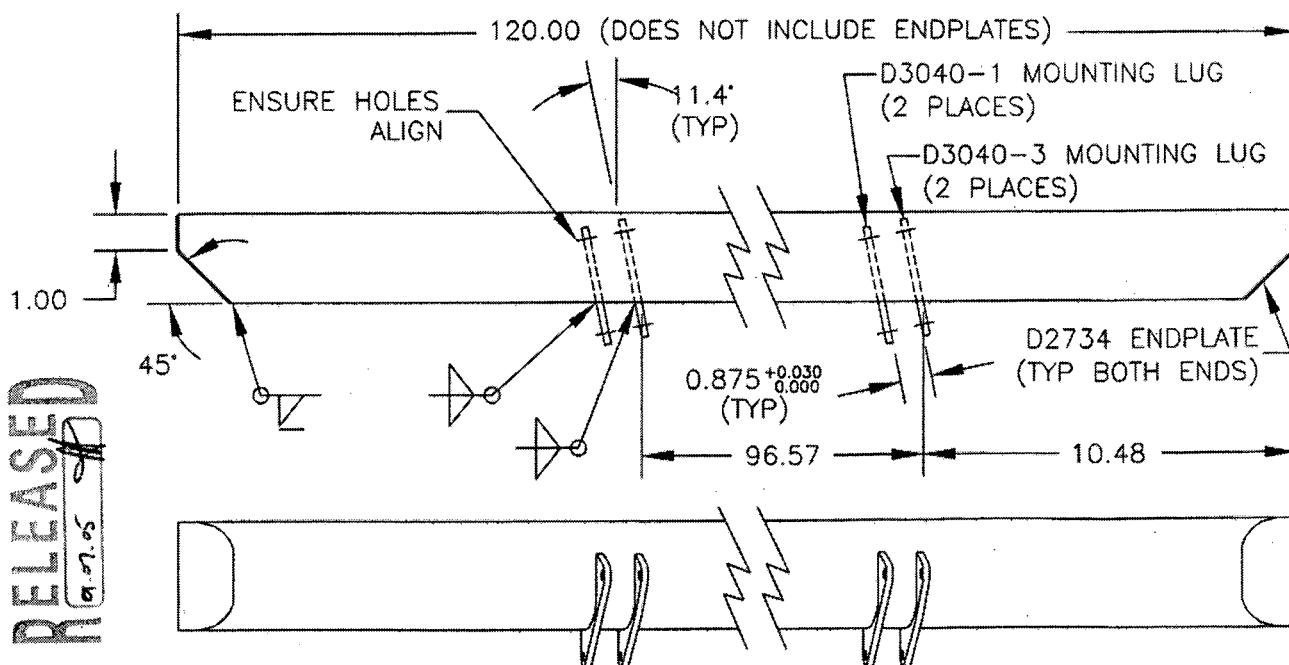
Date: 07.10.23



|          |          |          |    |                          |              |
|----------|----------|----------|----|--------------------------|--------------|
| DESIGN   | CP       | DRAWN BY | CP | DART AEROSPACE USA, INC. | REV. A       |
|          |          |          |    | PORT HADLOCK, WA         |              |
| CHECKED  | #        | APPROVED | #  | DRAWING NO.              | SHEET 2 OF 2 |
|          |          |          |    | D3043                    |              |
| DATE     |          |          |    | TITLE                    | SCALE        |
| 01.06.28 |          |          |    | A119 STEP WELDMENT       | 1:5          |
| A        | 01.06.28 |          |    | NEW ISSUE                |              |



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED  
R 07.05

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Change Record

|             |                       |
|-------------|-----------------------|
| Part Number | D119-675-011 / 1012   |
| Description | A119 HALL-ACCESS-STEP |

Page 1 of 1

| Chg. | Date     | By            | Relevant Documents  |
|------|----------|---------------|---|
| 001  | 01.07.05 | <del>JD</del> | PER MDL-D119-675 REV. A   |
| 002  | 01.09.06 | <del>JD</del> | CHANGE TO D3040-1/-3 PER D3040 REV. B<br>CHANGE TO D3041-1/-3 PER D3041 REV. A1 |
| 003  | 08.01.10 | <del>JD</del> | MDL-D119-675 REV. D ECN 1078  |
| 004  | 09/07/13 | <del>JD</del> | MDL-D119-675 REV. E, DED-D3041-C-1 ECN 09-627                                   |